

Work Order ID 142438

142438

Page 1

Wednesday, March 09, 2016 12:34:11 PM

Item ID: D5235-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: RH Step Assembly
 Start Date: 3/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: **MAR 09 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5235	A

110

0.05

110

Small Fab

Small Fab

Memo

0.00

1- ASSEMBLE FIXTURE DT10150 WITH BLOC "A","B" AND "C" TO MANUFACTURE D5235-042.

2- ASSEMBLE D5273-041 FITTINGS TO D5274-1 STEP WITH PROSEAL AS PER DWG
 A/R PROSEAL: 136953

3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10150 AND TRANSFER DRILL HOLES USING DT10186 FOR D5271-3/-4 AND DT 10185 FOR D5271-1 AS PER DWG AND NOTES 9,10.

4- DISASSEMBLE AND DEBURR.

5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5272-1/-3 TUBE AS PER DWG.

b) DEBURR

c) TOUCH UP HOLES WITH ALODINE ONLY

d) INSTALL NUTPLATES IN TUBES

6- TOUCH UP HOLES WITH ALODINE ONLY ON D5271-1/-4 AND D5273-041 FITTINGS.

7- USE DT10150 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER USING PROSEAL AS PER DWG
 A/R PROSEAL: 136953

DAS
36
9-89

2x 17/04/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	CURE TIME 24h: _____								
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				2			DAS 38 9-89 MAY 12 2017
130 *130* SprayPaint Spray Painting	Memo PRIME AS PER DWG AND QSI005 4.2.1.3.3 (LET CURE BEFORE PAINTING AS PER QSI005) PRC DESOTO PRIMER: <u>136772</u> PAINT AS PER DWG AND QSI005 4.2.2.3 WHITE IMIRON PAINT: <u>137327</u>	0.07 0.00				2			DAS 41 9-89 JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				2RH	d	all	12/05/14 DAS 15 9-89
150 *150* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>M137</u> <u>465</u> Memo	0.00 0.00				2RH	d	all	12/06/14
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2			DAS 38 9-89 JUN 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : 							
Misidentified	☐	Past Due	☐								

Work Order ID 142438***142438***

Page 4

Wednesday, March 09, 2016 12:34:11 PM

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

JUN 21 2017

17/6/21

DAS
21
9-89

JUN 21 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

Wednesday, March 09, 2016 12:34:14 PM

142438

D5235-042

Required Date: 4/1/2016

Required Qty: 4.00

Comments: IPP REV:A 15.12.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	*Qty Issued	Date Issued	Status
D5271-1		Manufactured	No				Each	0.0000		42			DAS 6 9-89
D5271-1									**	140320			
Forward Fitting													
D5271-4		Manufactured	No				Each	0.0000		42			DAS 6 9-89
D5271-4									**	140940 X1			
RH Aft Fitting													
D5272-1		Manufactured	No				Each	19.0000		42			DAS 36 9-89
D5272-1									**	140940 50 16/5/8		17/03/30	
Fwd Tube													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			18						
				140318			18			2			
				prelim			1						
				134701			1						
D5272-3		Manufactured	No				Each	19.0000		42			DAS 36 9-89
D5272-3									**			17/03/30	
Aft Tube													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			18						
				140815			18			2			
				prelim			1						
				134702			1						

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Wednesday, March 09, 2016 12:34:14 PM

Page 2

Work Order ID: 142438

142438

Parent Item: D5235-042

D5235-042

Parent Item Name: RH Step Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

D5273-041

Manufactured No

Each 1.0000

D5273-041

End Fitting Assembly

**

87
140324 DAS
9-89

Location

Loc Qty

Loc Code

prelim

1

135150

1

Each 0.0000

D5274-1

Manufactured No

D5274-1

Step Extrusion

B140326 (2x) **

42
17/03/30 DAS
36
9-89

D5291-041

Manufactured No

Each 179.0000

D5291-041

Radius Block Assembly

**

5628
DAS
6
9-89

Location

Loc Qty

Loc Code

prelim

4

135144

4

ST162

175

140319

175

Each 1,022.000

MS20426AD4-6

Purchased No

~~***MS20426AD4-6***~~

Rivet

**

11256
134502 x 12 DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1014

M128812

16

M133234

998

ST311

8

M132536

8

44
APR 07 2016

DAS
36
9-89

CR 3212-4-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 3

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Parent Item: D5235-042

D5235-042

Parent Item Name: RH Step Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

MS24694-S50

Purchased

No

Each

724.0000

48 24

MS24694-S50

134502

Screw

Location

Loc Qty

Loc Code

over006

400

m134370

400

ST284

324

m133031

24

m133990

300

MS24694-S98

Purchased

No

Each

274.0000

56 28

MS24694-S98

Screw

Location

Loc Qty

Loc Code

over006

200

m133990

100

m134134

100

ST283

74

m133483

74

28

APR 07 2016

DQA: _____ Date: _____



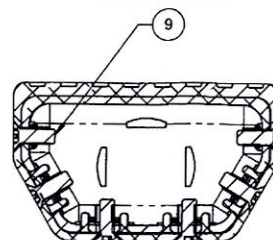
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

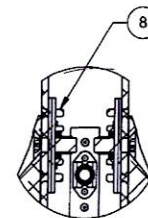
Work Order update only ☐

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
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Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

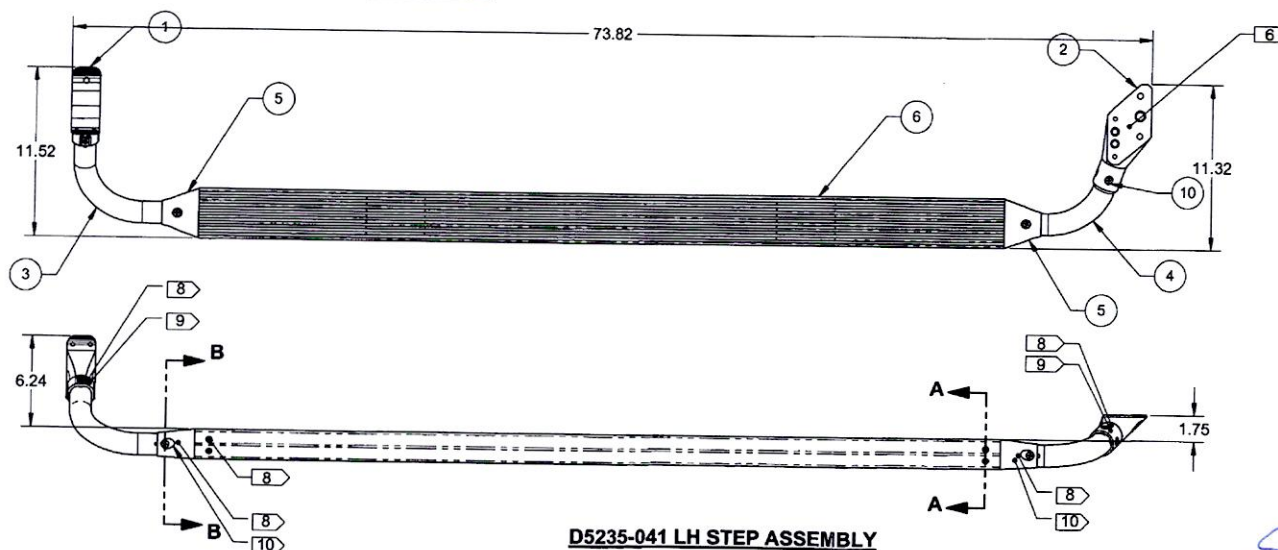
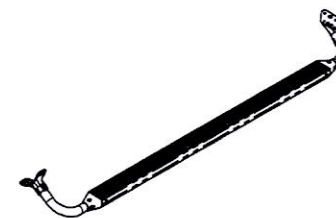
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1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



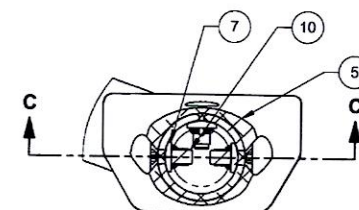
SECTION A-A



SECTION C-C



D5235-041 LH STEP ASSEMBLY



SECTION B-B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2. PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-041" PER QSI 044 6.1
- 7) WEIGHT: 10.49 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/3 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/3

RELEASED
2015-12-07
REN 15-649

APPROVED

A	ISSUE	CC	15.06.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CC		
DRAWN	CC		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.06.09		

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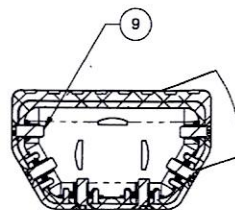
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SHEET 1 OF 4

TITLE **AW139 CABIN STEP** SCALE NTS

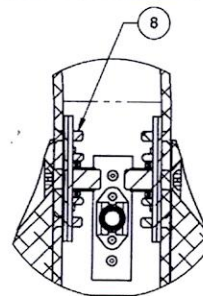
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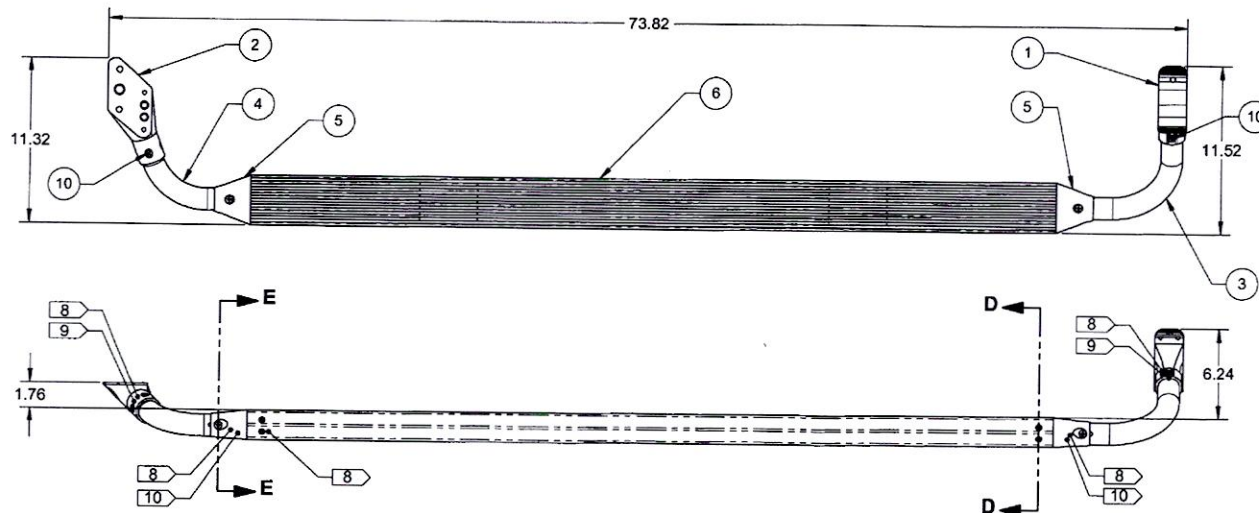
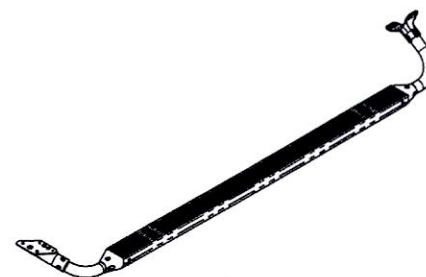
ITEM	QTY. -042	P/N	DESCRIPTION
	X	D5235-042	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



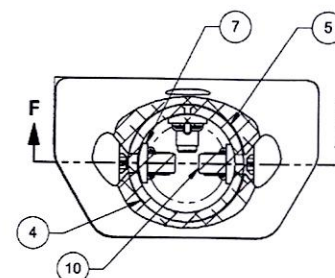
SECTION D-D



SECTION F-F



D5235-042 RH STEP ASSEMBLY



SECTION E-E

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-042" PER QSI 044 6.1
- 7) WEIGHT: 10.49 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/3

RELEASED
2015-12-07

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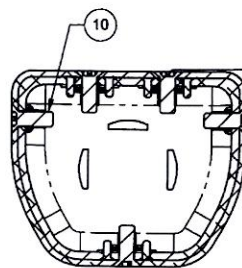
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CHECKED	VS
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DE APPR.	DS
DATE	15.06.09

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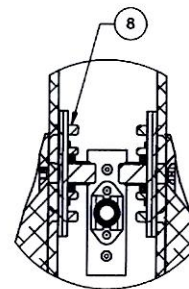
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SHEET 2 OF 4
TITLE **AW139 CABIN STEP** SCALE NTS

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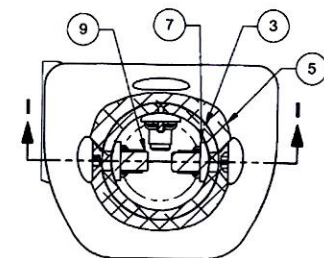
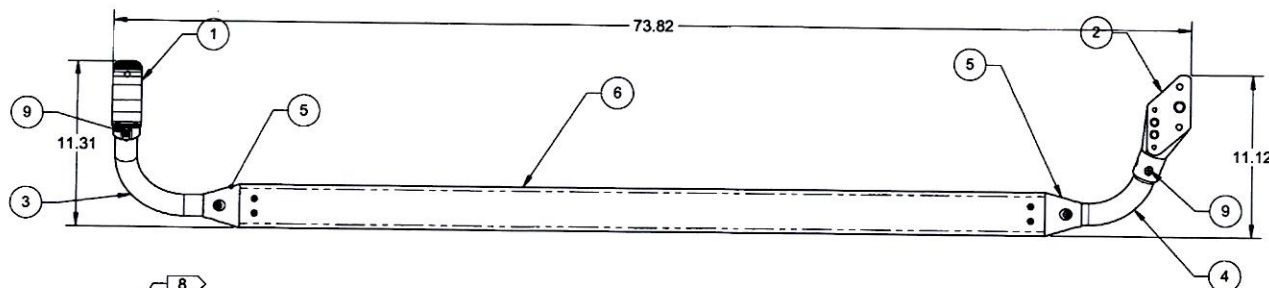
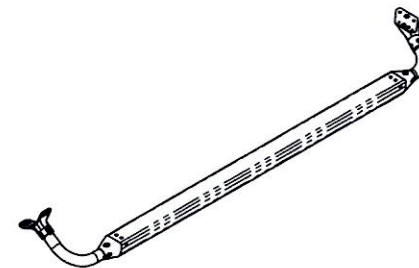
ITEM	QTY. -043	P/N	DESCRIPTION
	X	D5235-043	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-043	END FITTING
6	1	D5274-3	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



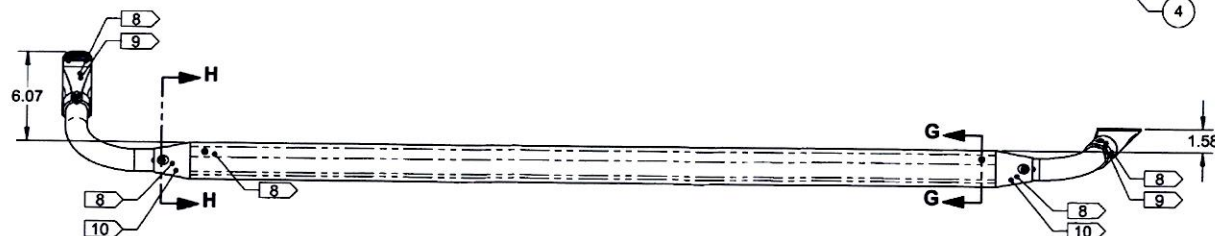
SECTION G-G



SECTION I-I



SECTION H-H



D5235-043 LH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-043" PER QSI 044 6.1
- 7) WEIGHT: 8.66 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/-3 TO D5272-1/-3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/-3

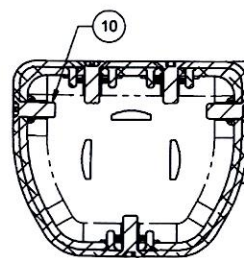
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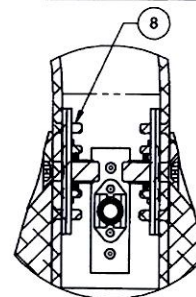
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DRAWN	CC	DRAWING NO.	REV. A
CHECKED	VS	D5235	SHEET 3 OF 4
MFG. APPR.	JLM	TITLE	SCALE
APPROVED	HS	AW139 CABIN STEP	NTS
DE APPR.	DS	DATE 15.06.09	

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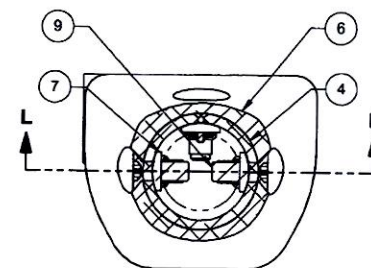
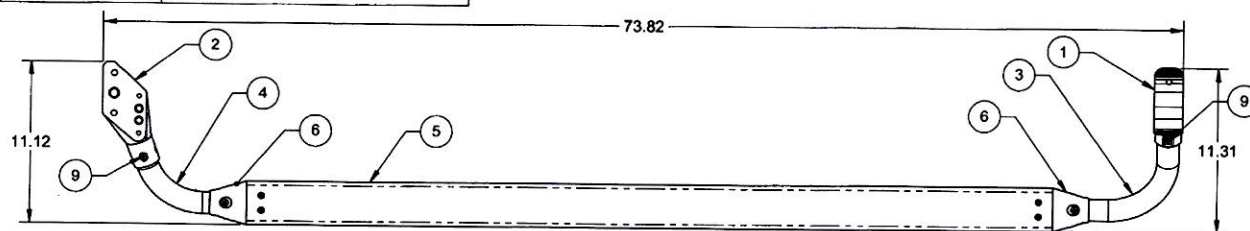
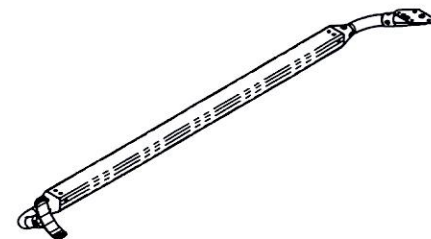
ITEM	QTY. -044	P/N	DESCRIPTION
	X	D5235-044	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	1	D5274-3	STEP EXTRUSION
6	2	D5273-043	END FITTING
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



SECTION J-J



SECTION L-L



SECTION K-K



D5235-044 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-044" PER QSI 044 6.1
- 7) WEIGHT: 8.66 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/3

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DRAWN	CC		
CHECKED	VS	DRAWING NO. D5235	REV. A
MFG. APPR.	JLM		SHEET 4 OF 4
APPROVED	HS	TITLE AW139 CABIN STEP	SCALE NTS
DE APPR.	D9		
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